

# Work Order ID 50368



Page 1

July 13, 2009 12:26:21 PM

Item ID: D2932-2

Accept



Setup Start



Revision ID: C

Stop



Item Name: Saddle RH Out, 206

Start Date: 7/15/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference: *7/13/09-07-16*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2932	Rev C

100



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

0.00

6

HAAS CNC vertical machine #1

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

*mwf 07/07/24*

B46410

110



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*mwf 07/07/24*

B46410

6

120



QC1- Inspect dimensions to dimension sheet

0.00

QC

Memo

0.00

Quality Control

*mwf 07/07/24*

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 50368

July 13, 2009 12:26:21 PM



Page 2

Item ID: D2932-2

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Setup Start



Revision ID: C

Stop



Item Name: Saddle RH Out, 206

Start Date: 7/15/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC8- Inspect parts - second check

0.00

H.A 09/07/24

(6)

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

H 09-07-27 X(6)

HandFinish

Hand Finishing

150



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BK 09-07-27 (6)

Powdercoat

Powder Coating

Memo

0.00

START TIME:

8:10

OVEN TEMPERATURE:

320°

9:10

FINISH TIME:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 50368



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July 13, 2009 12:26:21 PM

Item ID: D2932-2

Accept



Setup Start



Revision ID: C

Stop



Item Name: Saddle RH Out, 206

Start Date: 7/15/09 Start Qty: 6.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

H

09-07-22

06

QC

Quality Control

170

Identify as per dwg & Stock Location: 408A

0.00

9/1/07 6x50

Packaging

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

0.00

09/07/07 H9/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

July 13, 2009 12:26:21 PM

Work Order ID: 50368



Parent Item: D2932-2RevC



Parent Item Name: Saddle RH Out, 206

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003RevA		Manufactured	No			100	Each	43.0000	6.0000			

Saddle Billet, 7075



## Warehouse

### Location

Main Warehouse

MAT	43
46410	43

### Loc Qty

### Loc Code

(6)

mmw 07/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50368
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.127	.130	.127	.131		
B	0.100	0.140		.126	.130	.130	.132		
C	0.100	0.140		.106	.107	.113	.117		
D	0.210	0.230		.230	.230	.230	.230		
E	1.245	1.255		1.249	1.249	1.250	1.250		
F	1.245	1.255		1.249	1.251	1.250	1.249		
G	2.495	2.505		2.501	2.500	2.501	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.575	1.575	1.575	1.575		
J	2.495	2.505		2.497	2.499	2.500	2.499		
K	0.257	0.262		.259	.260	.260	.258		
L	0.312	0.317		.314	.314	.314	.316		
M	0.235	0.240		.237	.238	.238	.236		
N	0.100	0.140		.110	.108	.110	.109		
O	0.540	0.560	*	.560	.550	.554	.546		
P	0.490	0.510		.503	.499	.504	.504		
Q	3.715	3.725		3.715	3.717	3.715	3.717		
R	2.470	2.510		2.488	2.490	2.487	2.490		
S	0.240	0.270		.252	.257	.263	.261		
T	0.100	0.180		.130	.127	.123	.123		
U	1.625	1.635		1.626	1.627	1.628	1.625		
V	1.362	1.372		1.365	1.364	1.364	1.365		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.144	1.137	1.134	1.133		
Y	1.565	1.585		1.580	1.576	1.570	1.568		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	mmJ
Date:	09/07/23

Audited by:	B. A
Date:	09/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	Shaf

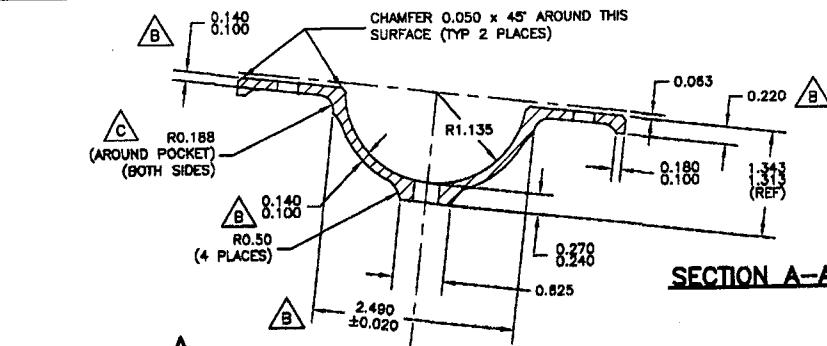
DART AEROSPACE LTD	Work Order:	SO368
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

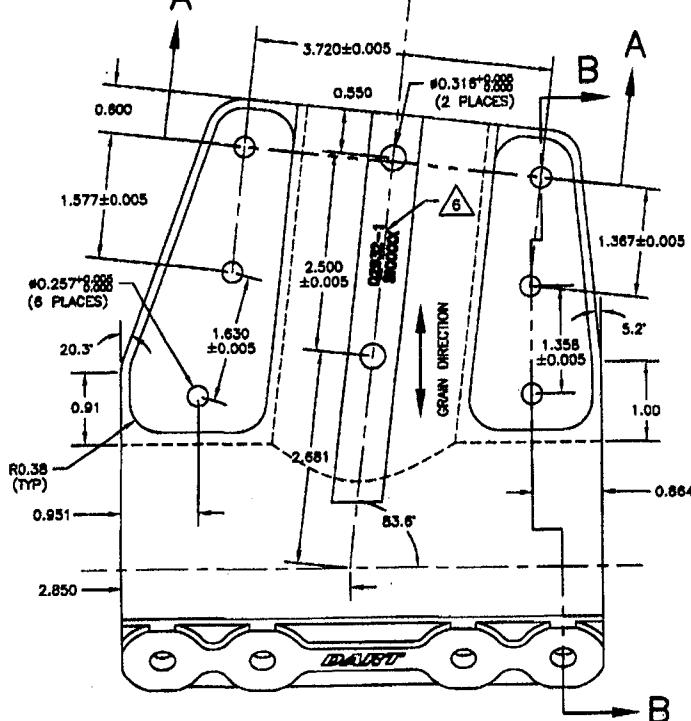
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.136	.138				
B	0.100	0.140		.134	.133				
C	0.100	0.140		.115	.125				
D	0.210	0.230		.220	.230				
E	1.245	1.255		1.249	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.499				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.576	1.576				
J	2.495	2.505		2.498	2.499				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.236	.236				
N	0.100	0.140		.110	.110				
O	0.540	0.560		.546	.545				
P	0.490	0.510		.503	.501				
Q	3.715	3.725		3.717	3.716				
R	2.470	2.510		2.489	2.488				
S	0.240	0.270		.263	.262				
T	0.100	0.180		.125	.127				
U	1.625	1.635		1.626	1.626				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321		.320	.320				
X	1.125	1.145		1.134	1.134				
Y	1.565	1.585		1.571	1.571				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	mjt	Audited by:	h.a
Date:	09/07/24	Date:	09/07/24

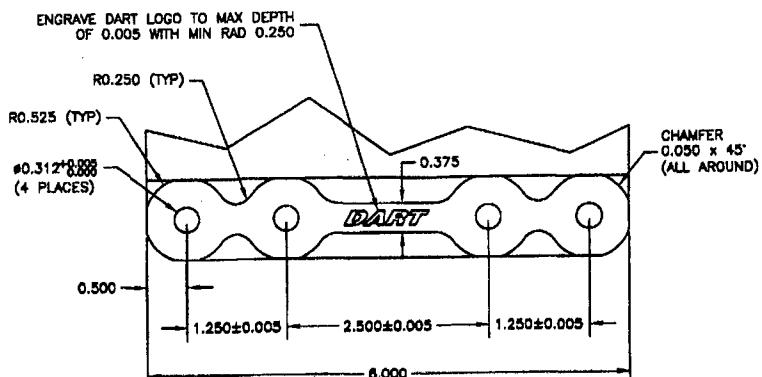
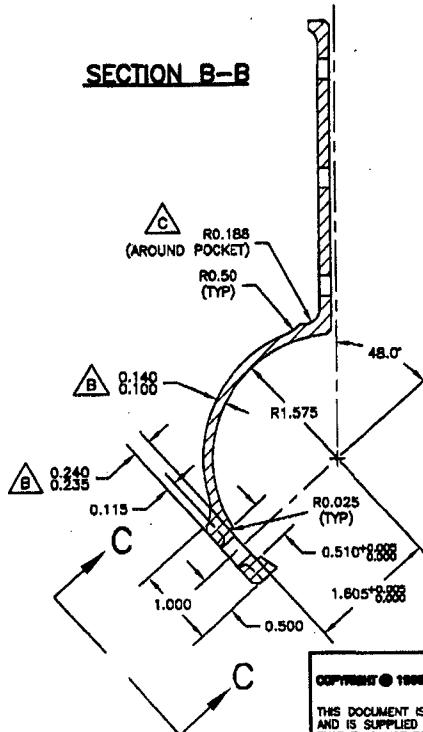
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	Shaffer



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

50368

NOTE:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. RELEVE, MA
CHECKED	APPROVED	DRAWING NO. REV. C D2932 SHEET 1 OF 1
DATE	TITLE	SCALE 06.11.09 SADDLE OUTSIDE 2:3

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07-02-12